

Date: Wednesday, 1/11/2006 4:15:36 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT WEB
Job Number	: 25435		
Estimate Number	: 10791		
P.O. Number	: N/A	Part Number	: D3282041
This Issue	: 1/11/2006 S.O. No. : N/A	Drawing Number	: D3282 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 24862	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/30/2006
Checked & Approved By	: <u>SEE ABOVE USER @ DAE</u>	Qty:	5 Um: Each
Comment	: Est Rev:B 05.09.23 Procedure change KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2792130	EXTRUSION
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2792-130 Extrusion B24030

Identify as D3282-1

IT 06-04-01 (3)

5

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3282.

IT 06-04-01 (3)

5

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

J.F./m 06/04/21

5

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F./m 06/04/21

5

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F.

06/04/23

(3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: FLOAT WEB

Job Number: 25435

Part Number: D3282041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

IT 06-04-29 (5)

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PL 06/04/29 (5)

8.0	D32831	Doubler
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

B25339

IT 06-04-29

9.0	MS20470AD47	Rivet, Universal Head
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Comment: Qty.: 57.0000 Each(s)/Unit Total : 285.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

M15924

IT 06-04-29

10.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web

AVR/ALPS-3 M17395

IT 06-04-29

11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

DP 06-5-2

(5)

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

DP 06-5-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PE Date: 06/05/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.04.21	3	Holes are 0.514" - 0.510" (instead of 0.520") are effected	CP 06.04.21 per Q51042	PARTS ARE OK per attached DS cnc.1	ml 06/04/21		CP 06.04.21 per Q51042	

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 25435

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/05/03 (5)

Job Completion



U 06/05/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

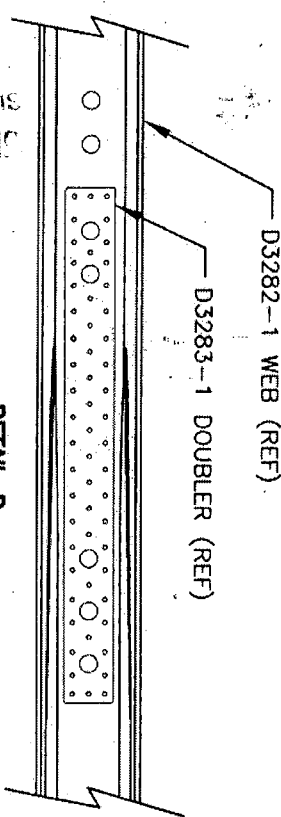
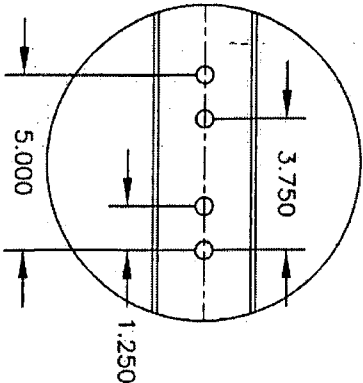
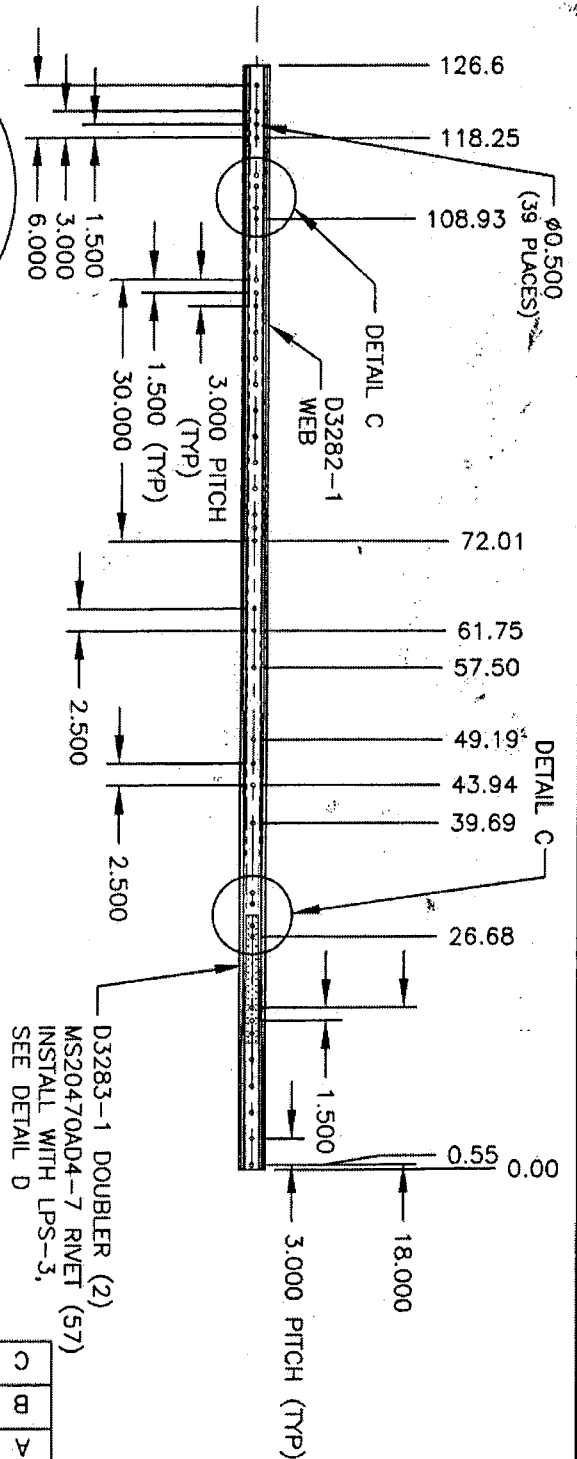
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		CP	DRAWN BY	CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. C SHEET 1 OF 2	DATE 05.08.09	TITLE FLOAT WEB, 206L/407	SCALE 1:20
CHECKED		#	APPROVED	#					
D3282		DRAWING NO.			REV. C	NEW ISSUE			
A		04.05.05			MOVE HOLES, ADD D3390-1 DOUBLERS				
B		05.03.16			REMOVE D3390-1, NOW MACHINED				
C		05.08.09							



- D3282-041 FLOAT WEB**
- 1) MAKE FROM D2792-130 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
 - 3) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
 - 6) SEE PAGE 2 FOR MACHINING DETAILS

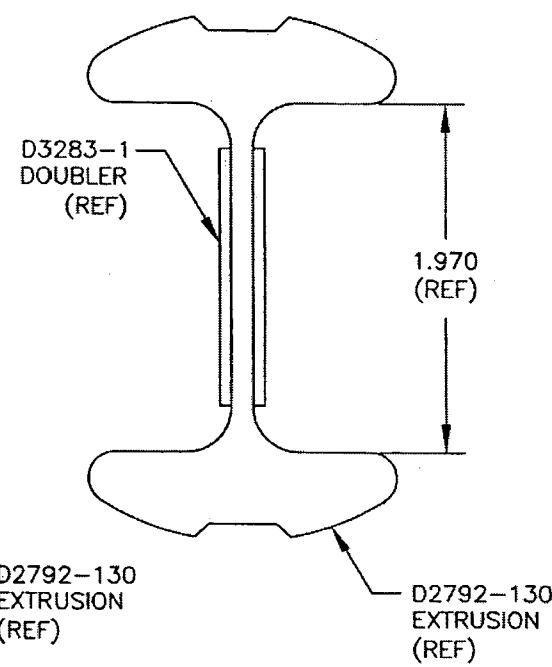
RELEASED
05-09-12

WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
RETURN TO
ENGINEERING
SHOP COPY

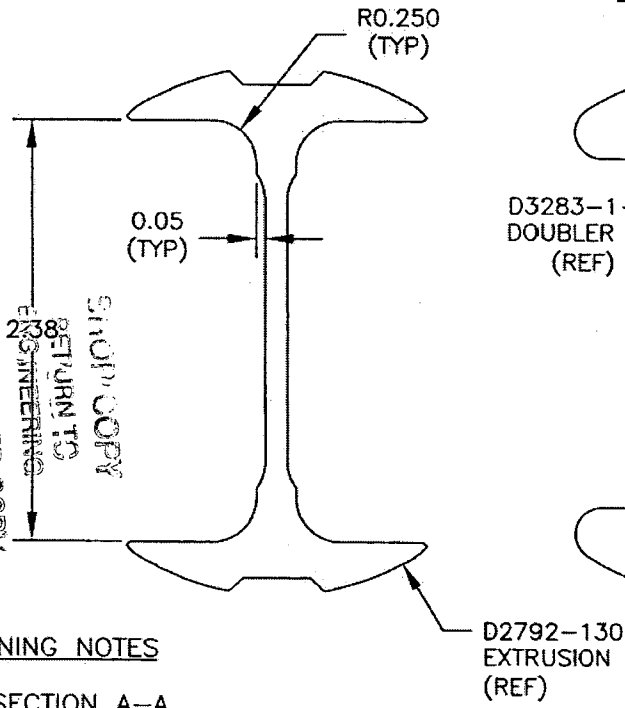
DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	REV. C
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA	SHEET 2 OF 2
DATE	05.08.09	TITLE	D3282	SCALE	1:20
			FLOAT WEB, 206L/407		

SECTION B-B



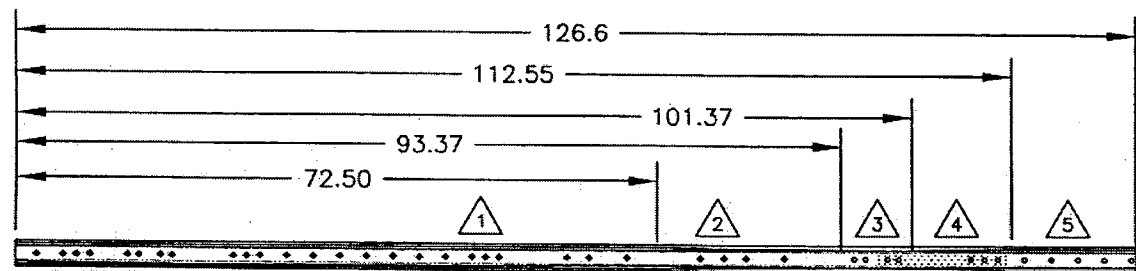
SECTION A-A



SNIP COPY
RETURN TO
ENGINEERING
COUNT ROLLED COPY
JECT TO AMENDMENT
WITH OUT NOTICE
WORK ORDER
NO. 25435

D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,
SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
05-04-12

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Chris Provencal

From: David Shepherd [davids@dartaero.com]
Sent: April 21, 2006 2:55 PM
To: Chris Provencal
Subject: Re: NCR D3282

Acceptable deviation.

David

----- Original Message -----

From: "Chris Provencal" <cprovencal@dartaero.com>
To: <davids@dartaero.com>
Sent: Friday, April 21, 2006 11:51 AM
Subject: NCR D3282

>
> David,
>
> The 0.500 OD holes in a D3282-041 float web have been oversized to 0.510
OD
> because of a bad drill. I don't think this is a problem, the effect of
the
> holes on the inertia value is very small.
>
> I will send a fax so you can see which holes.
>
> Sincerely,
> Chris Provencal
> DART Aerospace Ltd.
> Email..cprovencal@dartaero.com
> Phone...613-632-3336
> Fax.....613-632-4443
>
>